

Work Order ID 111808

Wednesday, January 22, 2014 2:40:21 PM

split 2

111808

BPH

Page 1

Item ID: PB67-43001-31 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Restraint Weldment
 Start Date: 1/22/2014 Start Qty: 6.00 Cust Item ID:
 Required Date: 1/29/2014 Req'd Qty: 6.00 Customer:
 Reference:

R *12*

Approvals: Process Plan: ME Date: 14-1-22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-31	Rev C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg B67-43001-321								
6061-090	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	***grain direction along 25.00" ***								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

12 0 Ae 14-01-30

12 0 Ae 14-01-30

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 Item Name: Upper Restraint Weldment
 Start Date: 1/22/2014 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/29/2014 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(12)	14.01.30		DAS 9 9-89
130 *130* Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg B67-43001	0.00 0.00			DAS 30 9-89	11			PTO 4/02/05
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(11)	14.02.05		DAS 9 9-89

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Item ID: PB67-43001-31

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Restraint Weldment

Start Date: 1/22/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/29/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

11 76, 14-25

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:35

FINISH TIME: 11:05

OVEN TEMPERATURE:

11 14-26 DAS 34 9-89

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

11 d 14-02-12 DAS 19

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Item ID: PB67-43001-31 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Restraint Weldment
 Start Date: 1/22/2014 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/29/2014 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Small Fab	Small Fab	0.00				5	0		ll 14-2-12
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg B67-43001								
190 *190* QC	QC5- Inspect part completeness to step on W/O	0.00				5	0		DAS 9 9-89
Quality Control	Memo	0.00							
200 *200* Packaging	Identify as per dwg & Stock Location: 14-02-13 Mazz 2	0.00				5	0		ll 14-02-12
Packaging	Memo	0.00							



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Item ID: PB67-43001-31

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Restraint Weldment

Start Date: 1/22/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/29/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

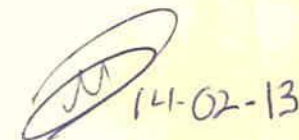
210

QC

Memo

0.00

Quality Control



Picklist Print

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Work Order ID: 111898

Parent Item: PB67-43001-31

Start Date: 1/22/2014

Required Date: 1/29/2014

Parent Item Name: Upper Restraint Weldment

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-20 new issue DD verified by:ec
dwg EC verified by:DD
IPP Rev C 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.090
6061-T6 .090 Sheet

Purchased

No

180

sf

27.0000

0.434

4

~~AC 11-11-15~~

Location

Loc Qty

Loc Code

MAT021

27

123279

27

MS27039-1-08
Screw

Purchased

No

180

Each

1,054.0000

5

30

123279 → (6)
14.02.12

Location

Loc Qty

Loc Code

GA

51

m125654

51

st507

1003

m126319

3

m127255

500

m127813

500

NAS1149D0316J
Washer

Purchased

No

180

Each

1,526.0000

5

30

25
14.02.12

Location

Loc Qty

Loc Code

ST293

1000

M127993

1000

ST294

126

123482

126

ST510a

400

M127956

400

PB67-43001-33
Upper Pad Assembly

Manufactured

No

180

Each

5.0000

1

6

14.02.12

Location

Loc Qty

Loc Code

Mezz2

5

100033

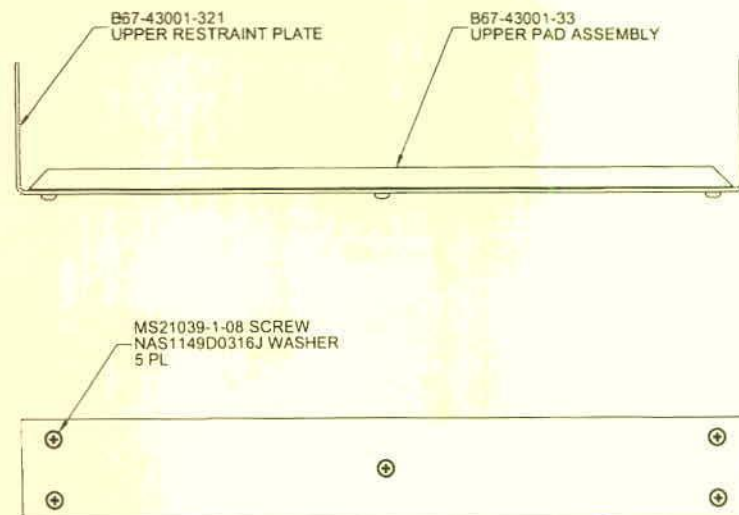
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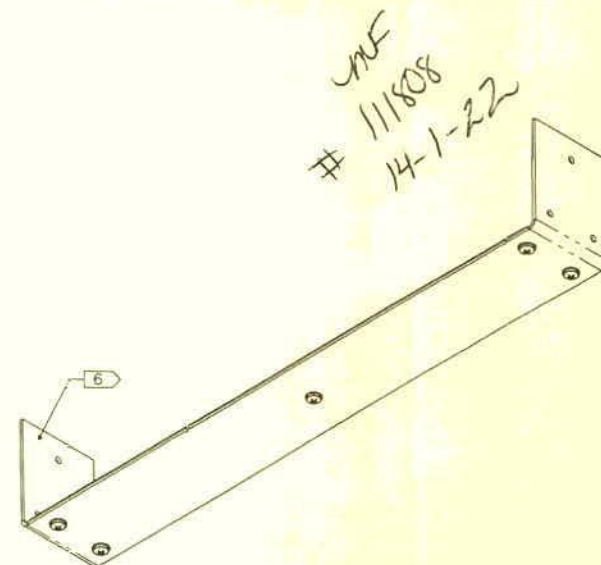
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ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-31	UPPER RESTRAINT ASSEMBLY
3	1	B67-43001-33	UPPER PAD ASSEMBLY
4	1	B67-43001-321	UPPER RESTRAINT PLATE
6	5	MS27039-1-08	SCREW
7	5	NAS1149D0316J	WASHER



B67-43001-31 UPPER RESTRAINT ASSEMBLY



RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 041. FOR PREVIOUS REVISIONS, REFER TO SHEET 41 OF PREMIER AVIATION DRAWING No B67-43001. REASON: SEE PAR#09-011)		MB	09.06.'19
REV	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	AS	B67-43001-31	SHEET 1 OF 1	
APPROVED	AS	TITLE	SCALE	
DE APPR	N/A	UPPER RESTRAINT ASSEMBLY	NTS	
DATE	09.06.19	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD		

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-31" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs

